

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026862**Date Inspected:** 02-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shigang/Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 9

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 009 located on 3018TR1-001. Welder is identified as 059421. ZPMC Quality Control (QC) is identified as Chen Shigang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 031 located on 3018TR1-001. Welder is identified as 059416. ZPMC Quality Control (QC) is identified as Chen Shigang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 031 located on 3018TR1-001. Welder is identified as 059418. ZPMC Quality Control (QC) is identified as Chen Shigang. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Heat Straightening

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# WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress: ZPMC personnel heat straightening Bike Path Travel Rail member identified as 3017TR1-001. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Chen Shigang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) Number (B)-10415

This QA Inspector observed the following work in progress: ZPMC personnel heat straightening Bike Path Travel Rail member identified as 3017TR2-001. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Chen Shigang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) Number (B)-10415

## Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09855.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

DHMFD-A1-P7  
DHMFD-A1-P7  
DHMFD-A2-P7  
DHMFD-A3-P7  
DHMFD-A4-P7  
DHMFD-A5-P7  
DHMFD-A6-P7

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt,Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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